

Date: Monday, 30/10/2006 12:57:11 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STOP
<b>Job Number</b> : 29224	
<b>Estimate Number</b> : 10514	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D28051
<b>This Issue</b> : 30/10/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2805 REV. B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 27616	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : _____	<b>Due Date</b> : 30/10/2006 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
<b>Comment:</b> Qty.: 0.2756 f(s)/Unit Total : 1.6538 f(s) 6061-T6 Bar 1.5" x 1.5" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" (M6061T6B1500X01500) Batch: <i>M16954 m/06/10/30</i> 6		
2.0	BAND SAW	BAND SAW
<b>Comment:</b> BAND SAW Cut Bar: 3.150" Long +0.010/-0.030" <i>m/06/10/30</i> 6		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr Identify as D2805-1 <i>m/06/10/30</i> 6		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>m/06/10/30</i> 6		
5.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK <i>J.F. 06/10/31</i> (6)		

PTD

Date: Monday, 30/10/2006 12:57:12 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 29224

Part Number: D28051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YC 06/10/31 x 6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

SP 06/10/31 6

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

GA 06/10/31  
ST 06/10/31

(3)  
(3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

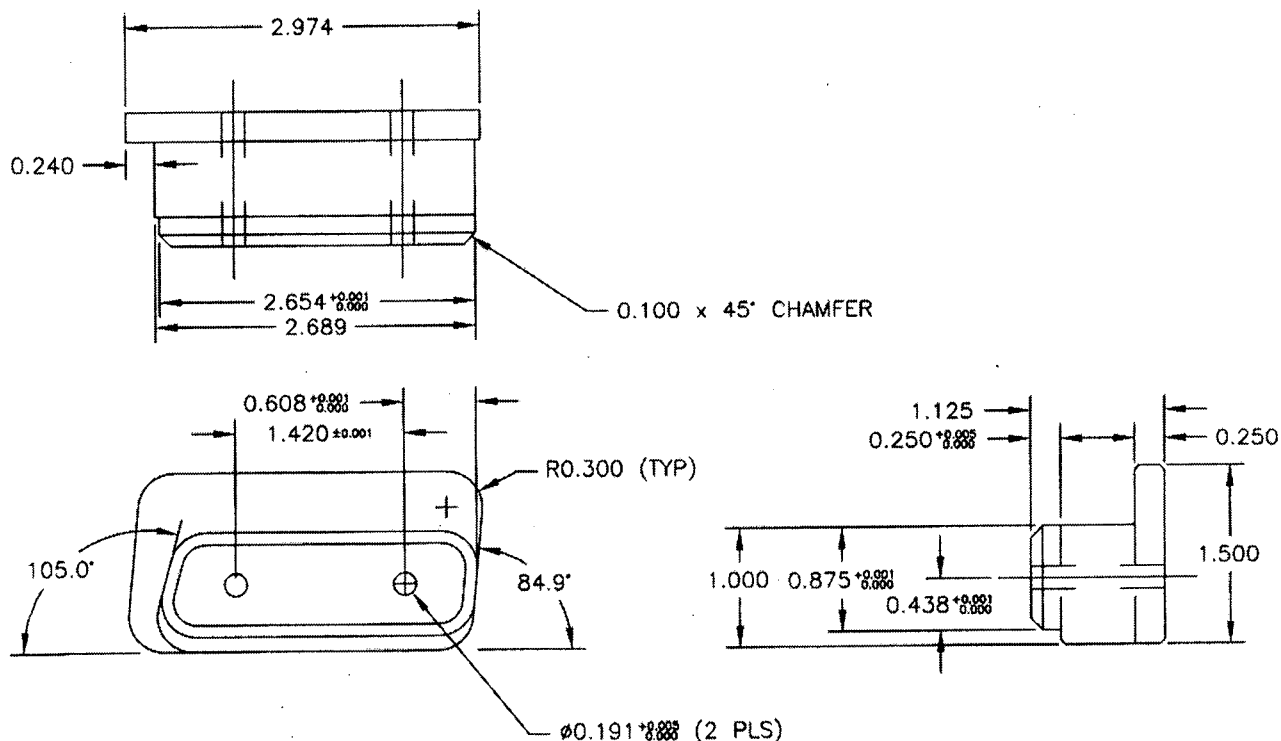


U 06/10/31



DESIGN		DRAWN BY	LP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2805	SHEET 1 OF 2
DATE	01.03.13	TITLE	STOP	SCALE	2:3
A	00.10.31	NEW ISSUE			
B	01.03.13	ADD -3/-4			

RELEASED  
01.03.16



D2805-1 (SHOWN)  
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.  
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

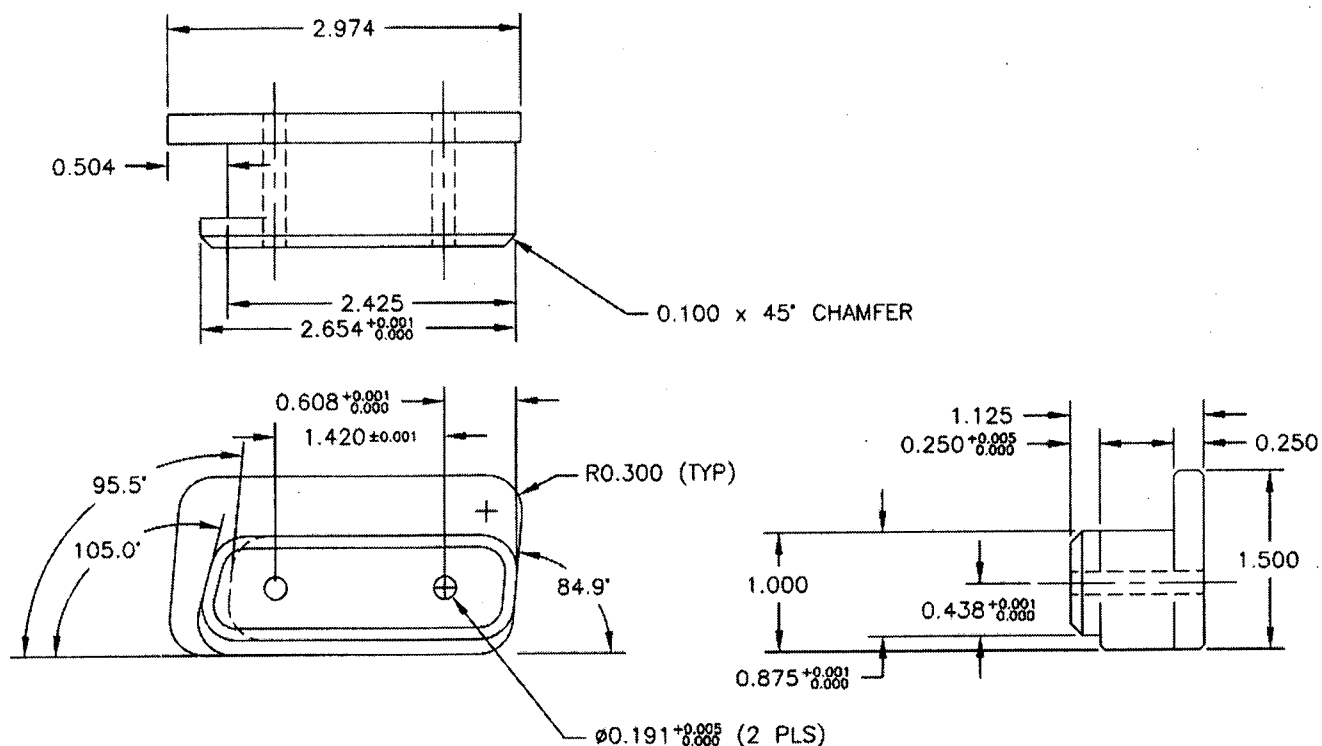
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED  
01.03.16



D2805-3 (SHOWN)  
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.  
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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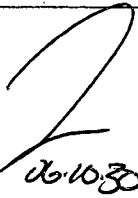
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W/O: 29224		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/30	3	<del>the dim.</del> the dim. .875 too small & .865 the E-mill <del>with</del> the wobble		Change tools. Scrap part: des frag. Replace.				

NOTE: Date & initial all entries